

# Work Order ID 72912

Monday, October 24, 2011 1:49:54 PM

**\*72912\***

*DUPLICATE*

Page 1

Item ID: D206-628-032

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Heli-Access-Step RH

Start Date: 8/18/2011 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals:

Process Plan:

*MF*

Date: *11-10-24*

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev N/A								

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-032 CHG 003

*8 u/10/26*

*for MLJ 11-10-24*  
*(2)*

110

Pick Kit

0.00

**\*110\***

Packaging

Memo

0.00

Packaging

*SP 11-10-24*

120

QC4- 100% Inspect kits for completeness

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*8 u/10/26*

*72*  
*RH*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 72912****\*72912\***

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Item ID: D206-628-032

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Heli-Access-Step RH

Start Date: 8/18/2011 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

**\*130\***

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-628-032

Location: 102PPP Rev: 2Sp 11-10-26

140

0.00

**\*140\***

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

11/10/26mf  
11-10-26

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 72912

Parent Item: D206-628-032

Start Date: 8/18/2011

Required Date: 8/25/2011

Parent Item Name: Heli-Access-Step RH

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM  
IPP Rev:E as per ecn 1118 08-02-05 DD verified by:EC IPP Rev:F as per chg 003 DD  
10.02.25 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-13A Bolt		Purchased	No			110	Each	1,136.0000	4	8			

Location	Loc Qty	Loc Code
ST357	1136	
118078	590	
118706	46	
118838	500	

AN4-14A Bolt		Purchased	No			110	Each	223.0000	4	8			
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Location	Loc Qty	Loc Code
ST357	223	
118628	100	
118706	23	
119127	100	

AN4-15A Bolt		Purchased	No			110	Each	559.0000	4	8			
-----------------	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST358	559	
118112	4	
118648	255	
118706	200	
119127	100	

AN960JD416 Washer	NAS1149D0463J	Purchased	No			110	Each	0.0000	12	24			
D2724-042 206L Step Assembly		Manufactured	No			110	Each	0.0000	1				

m 119042

80 11-10-24  
B72915 11/10/25

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

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Page 2

Work Order ID: 72912

Parent Item: D206-628-032

Parent Item Name: Heli-Access-Step RH

Start Date: 8/18/2011

Required Date: 8/25/2011

Start Qty: 2.00

Required Qty: 2.00

~~D2731-3~~ Manufactured No

Mounting Lug

110 Each 108.0000

4

8

SP

Location

Loc Qty

Loc Code

ST469

108

47967

5

52329

23

73417

80

1X  
7x

Manufactured No

110 Each 4.0000

8

B#3759

16x

SP

Location

Loc Qty

Loc Code

ST409

4

56515

0

64283

4

Manufactured No

110 Each 74.0000

4

8

SP

Location

Loc Qty

Loc Code

ST474

74

73418

34

74505

40

8x

Purchased No

110 Each 13,733.000

12

24

SP 11-10-24

Location

Loc Qty

Loc Code

ST300

2733

117441

51

117601

537

118451

1145

118927

1000

24x

ST516

6000

119017

6000

ST518

5000

119075

5000

~~D3394-041~~ Lug Assembly

~~MS21042L4~~ Nut

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Shop Packet Print

Page 2

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



REFERENCE

DART AEROSPACE USA, INC.

IIN-D206-628

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5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS-  
STEPS™ PARTS LIST

Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	Part Number	Description
X					✓	D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
1						D2721-041	STEP ASSEMBLY LH
	1					D2721-042	STEP ASSEMBLY RH
		1		1		D2724-041	STEP ASSEMBLY LH
			1		1	D2724-042	STEP ASSEMBLY RH
				4	4	D2731-3	MOUNTING LUG
4	4	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
				4	4	D3394-041	MOUNTING LUG
				4	4	*D3394-1	*MOUNTING LUG
				8	8	*MS35489-93	*GROMMET
4	4	4	4			D3394-043	MOUNTING LUG
4	4	4	4			*D3394-3	*MOUNTING LUG
8	8	8	8			*MS35489-93	*GROMMET
4	4			4	4	AN4-13A	BOLT
4	4	4	4	4	4	AN4-14A	BOLT
4	4	8	8	4	4	AN4-15A	BOLT
12	12	12	12	12	12	NAS1149D0463J	WASHER (AN960JD416)
12	12	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

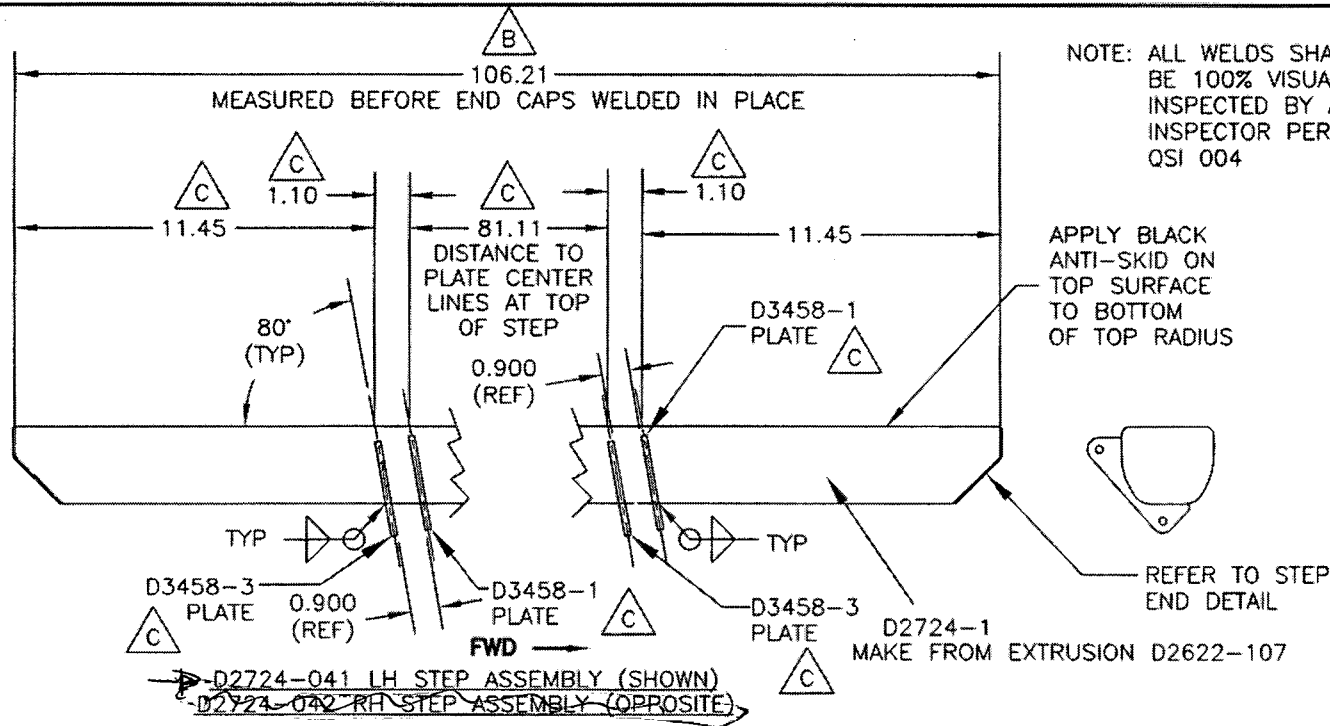
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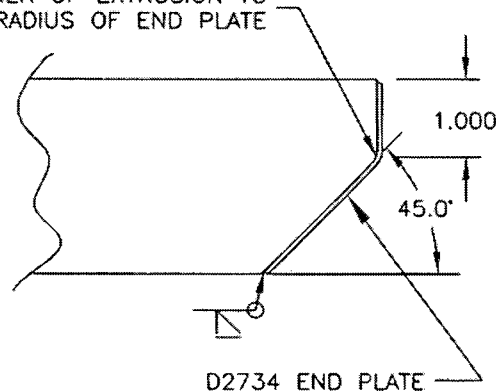
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Date: 11.02.25

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ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



#### D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

#### D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
05.11.14

DART

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.19	TITLE	D2724	DRAWING NO.
				SHEET 1 OF 1
				SCALE
				NIS
				REV. C
				RE-DESIGN, ADD D3458-1/-3
				206L/407 STEP ASSEMBLY
				NEW ISSUE
				97.12.04
				98.10.19
				05.09.19
				05.09.19